Work Orde Thursday, Novem											Page 1
	D3278-041			Accept					Setup Sta	rt	
Revision ID: Item Name:	Support Assem				. 1				Sto		
Start Date: Required Date: Reference:	11/4/2010 11/19/2010	<b>Start Qty:</b> 40.00 <b>Req'd Qty:</b> 40.00	1 10011 01011 01011 01 1 10011 01011 01	II ( <b>EE</b> )	Cust Item I Customer:	D:					
Approvals:	Process Plan	n:/	Date:///-	Tooling:	D:	ate:		F	Run Sta		
	QC:	7	Date:	SPC (Y/N):	D	ate:			Sto	p	
Sequence ID/ Work Center ID	)	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr									
D3278	Rev	С								,	
100 		Small Fab		0.00				2/3	11/0	///	140
Small Fab		Memo Rivet spacer	s with support as per Dv				/		/ .		
110 		QC5- Inspect part compl	eteness to step on W/O	0.00	ω <b> </b>			counts (440	)		

Quality Control

Memo

120

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Assemble support as per Dwg D3278.□\*\*\*DO NOT TIGHTEN BOLTS\*\*\*□Identify as D3278-041

Dart Ae	rospace	e Ltd							•
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No <b>DQ</b>	<b>4</b> :	_ Date: _	
	R	esolution:	Disposition	1:	_ QA: N/C Cld	sed:		Date: _	
NCR:	- M	1	WORK ORDI	ER NON-CONFORMA	ANCE (NCR	)		· · · · · · · · · · · · · · · · · · ·	
DATE	OTED	Description of NC		Corrective Action Secti	·	Verific	ation	Approval	Approval
DATE	STEP	. Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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									·
						,			

## Work Order ID 63553

Thursday, November 04, 2010 10:03:36 AM



Page 2

Item ID:

D3278-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Support Assembly

**Start Date:** 

11/4/2010

**Start Qty: 40.00** 

**Required Date:** 11/19/2010

Req'd Qty: 40.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

QC:

Process Plan: Date:

Tooling:

**SPC (Y/N):** 

Date: Date:

Run

Start Stop



Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Date:

Set Up/ Run Hours

Tool ID

Tool # Plan

Qty Code

Accept

Reject Qty

Reject Insp. Number Stamp

140

Packaging

Packaging

Memo

Identify as per dwg & Stock Location:

Memo

0.00

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Ae	rospace L	.td							
W/O:			WC	RK ORDER CHANGE	ES		<u> </u>		t
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Res	olution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	₹)			
DATE	0750	Description of NC		Corrective Action Section	n B	Verifie	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspector
		·							
***						<del></del>			

## **Picklist Print**

Thursday, November 04, 2010 10:03:40 AM

Work Order ID: 63553

D3278-041 Parent Item:

Parent Item Name: Support A embly



Start Date: 1/4/2010

**Start Qty:** 40.00

**Required Date: 1./19/2010** 

Page 1

Required Qty: 40.00

Comments:

IPP: □A□04.04.19□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1		Manufactured	No			100	Each	11.0000	ہے ا	40,	/01/	10	
				Location	1	Loc	<u>Oty</u>	Loc Code			B62	482 (	362
				ST045			4		_	- //		, ,	
				ST048	60564		4			- 9	-		
				31040	51353		7		_		-		
D3278-2		Manufactured	No			100	Each	9.0000		40/5	- 11   0.	//0	
				Location	<u>l</u>	Loc	<u>Qty</u>	Loc Code			B624	183	(27)
				ST048	60565		9 9			<b>-</b>	- -	0 5	332
D3278-3  Spacer		Manufactured	No		00363	100	Each	74.0000		49/3	11/0	/ 2//	. 0
Space				Location	<u>1</u>	Loc	Oty	Loc Code					•
				ST045			74		_	- ( ( )	_		
					60244		74			40	_		

## **Dart Aerospace Ltd**

									` <u> </u>
W/O:			WO	RK ORDER CHANGE	ES		. ,		
DATE	STEP	PRC	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	٨:	Date:	· · ·
	Re	esolution:	Disposition	:	QA: N/C CI	osed:		Date: _	<del></del>
NCR:			WORK ORDE	R NON-CONFORMA	NCR: Yes No DQA: Date: QA: N/C Closed: Date:  FORMANCE (NCR)  Section B  Verification Section C				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign 8				Approval QC Inspector
			Office Ellig	Office Eng	Date				
						,			

Thursday, November 04, 2010 10:03:40 AM

Work Order ID: 63553

Parent Item:

D3278-041

Parent Item Name: Support Assembly



Start Date: 11/4/2010

Required Date. 11/19/2010

**Start Qty: 40.00** 

Required Qty: 40.00

MS21042L4



Purchased

No

100

2,779.000 Each



<u>Location</u>	Loc Qty	Loc Cod
ST300	2779	
113422	25	
114523	8	
115589	1646	
115621	1100	
	120 Eac	h 413.000

AN4-13A



Locution			Doc Oty	Loc Cou
ST300			2779	
1	13422		25	
1	14523		8	
1	15589		1646	
1	15621		1100	
		120	Each	413.000

000

Bolt

Location	<u>1</u>	Loc Qty	Loc Code
ST357		300	
	115936	300	
ST358		113	
	115159	113	



Manufactured

Purchased

No

No

120 Each

24.0000

Washer

(	160 X)	
	<b>Location</b>	

ST300

Loc Qty 24 24

Each

Loc Code

113288

120

17.0000

Lug

D2230-1

Location	Loc Qty	Loc Cod
ST430	14	
62665	14	
ST476	3	
61713	3	

Dart Ae	rospace L	td							
W/O:			WO	RK ORDER CHANGI	ES			· · · · · · · · · · · · · · · · · · ·	<u> </u>
DATE	STEP	PRO	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	Res	olution:	Disposition	:	_ QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section	on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	. 1	ion C	Chief Eng	QC Inspector
					ļ.				

DATE STEP Description of NC Section A Section A Section C Section A Section C Section A Section C Section

## **Picklist Print**

Thursday, November 04, 2010 10:03:40 AM

Page 3

Work Order ID: 63553

Parent Item:

D3278-041

Parent Item Name: Surport Assembly



Start Date: 11/4/2010

Required Jate: 11/19/2010

**Start Qty: 40.00** 

Required Qty: 40.00

MS20426AD3-6

Purchased

No

120

1,330.000

Each

Loc Qty

1330

Location ST316

105055

1330

Loc Code

Rivet

Dart Ae	rospace Lt	d						1
W/O:			WORK ORDER	CHANGES				
DATE	STEP		PROCEDURE CHANGE	В	y Dat	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•						
								<u> </u>
Part No	):	PAR #	: Fault Category:	NCR:	Yes No	DQA:	Date: _	
	Reso	lution:	Disposition:	QA: N/	C Closed		Date: _	
NOD		т.	WORK ORDER NON-CO	NEODMANCE (	ICB)			

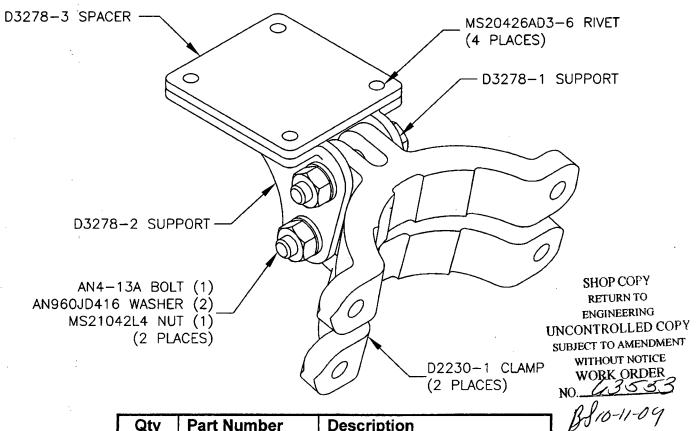
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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l	-43	#\ '	D3278 SHEET	1 OF 3
DATE			TITLE	SCALE
07.0	07.24		SUPPORT ASSEMBLY	NTS
Α		04.03.03	NEW ISSUE	
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
С		07.07.24	CHANGED RIVETS PER PAR #185	



## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description				
X	D3278-041	SUPPORT ASSEMBLY				
1						
2	D2230-1	CLAMP				
1	D3278-1	SUPPORT				
1	D3278-2	SUPPORT				
1	D3278-3	SPACER				
2	AN4-13A	BOLT				
4	AN960JD416	WASHER				
4	MS20426AD3-6	RIVET				
2	MS21042L4	NUT				

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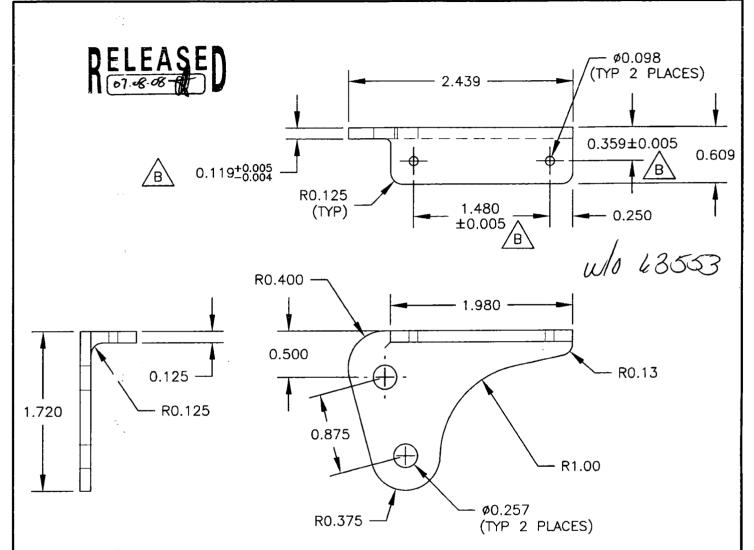
## Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					·						
Part No	:	PAR	#: Fault Category:	NCF	R: Yes	No <b>DQ</b>	<b>A</b> :	Date:			
	R	esolution:	Disposition:	QA:	N/C C	losed:		Date: _			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Verification Approval	Annroyal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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<del>-</del> #	<b>-</b>	D3278	SHEET 2 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1



# D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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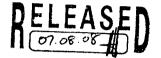
## **Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Category:	NCR: Yes	s No <b>DQ</b>	<b>A</b> :	Date:				

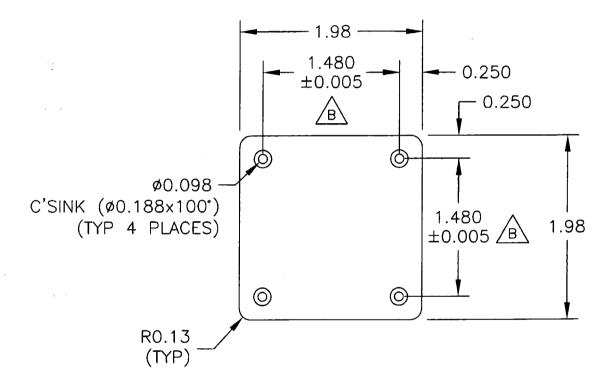
Resolution:		olution:	Disposition	on:	QA: N/C Clos	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMAL	NCE (NCR)		<del>1-1/</del>	<del></del> ,
		STED Description of NC		Corrective Action Section	ı B	Verification		<b>A1</b>
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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ľ	DATE		TITLE	SCALE
	07.07.24		SUPPORT ASSEMBLY	1:1



wlo 43553



### D3278-3 SPACER

1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR

DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-S.125)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:			W	ORK ORDER CHANG	ES	, .	····		
DATE STEP		PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
ŧ									
Part No		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date: _	
	Resc	olution:	Disposition	on:	_ QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	ion B Sign	& Sect	cation tion C	Approval Chief Eng	Approval QC Inspector